

Work Order ID 70859

Thursday, June 16, 2011 2:38:36 PM



Page 1

Item ID: D3805-5

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 6/16/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *11-06-11*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3805

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

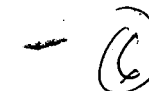
1-Cut as per Dwg D3805

Dwg Rev: *A*

Prog Rev: *A*

2-Debur if necessary

B11-6-23



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



0.00 8/16/23

QC

Memo

Quality Control



130

0.00



0.00

Brake NC

Memo

Brake NC

Form as per Dwg D3805 using Jigs DT8261 and DT8326

SB 11/6/27



140

QC5- Inspect part completeness to step on W/O

0.00



0.00 8/16/23

QC

Memo

Quality Control



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Page 3

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Setup Start



Revision ID:

Stop



Item Name: Plate

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Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: *W/A*

0.00



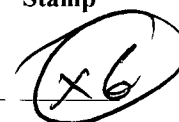
Packaging

Memo

0.00

Packaging

EL 11-6-29



160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/59

MF 11-08-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 16, 2011 2:38:42 PM

Page 1

Work Order ID: 70859



Parent Item: D3805-5



Parent Item Name: Plate

Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

100

sf

119.0550

1.587

10.02316



B116-23

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

119.055

112178

3.4

113062

13.655

116979

69

117653

33

117653

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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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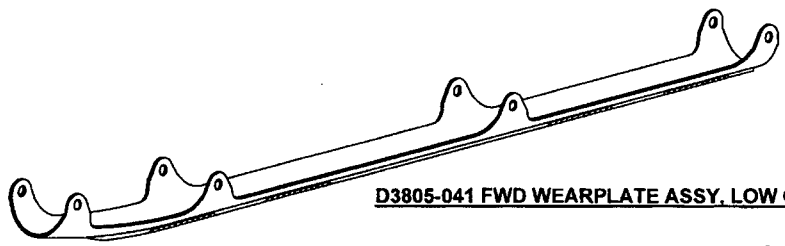
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

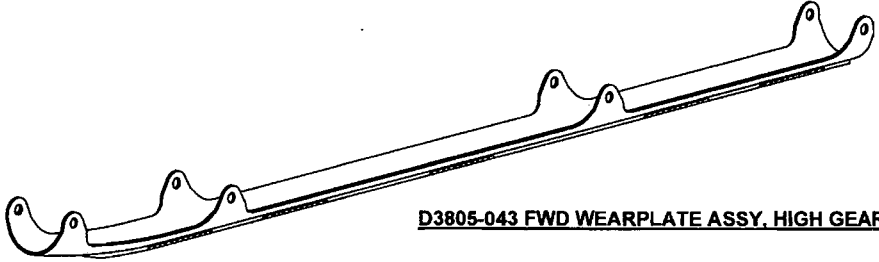
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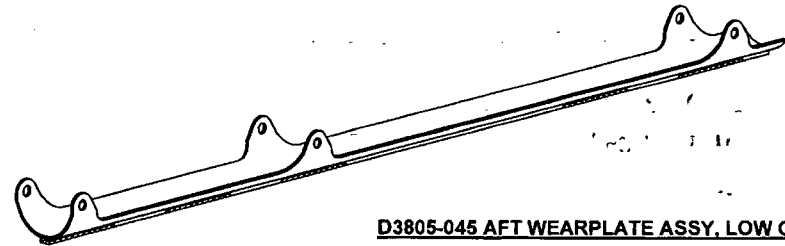
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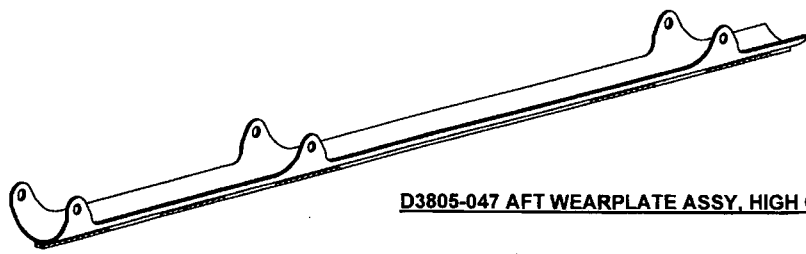
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70859

011-06-11

RELEASED
47 09.03.03
Per ECN 09-538
UNDER REVIEW
NO LONGER UNDER REVIEW
Per PART-100

A NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D3805 TITLE WEARPLATE ASSY	REV. A	SHEET 1 OF 8
DRAWN		SCALE	NTS
CHECKED			
MFG. APPR.			
DE APPR.			
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

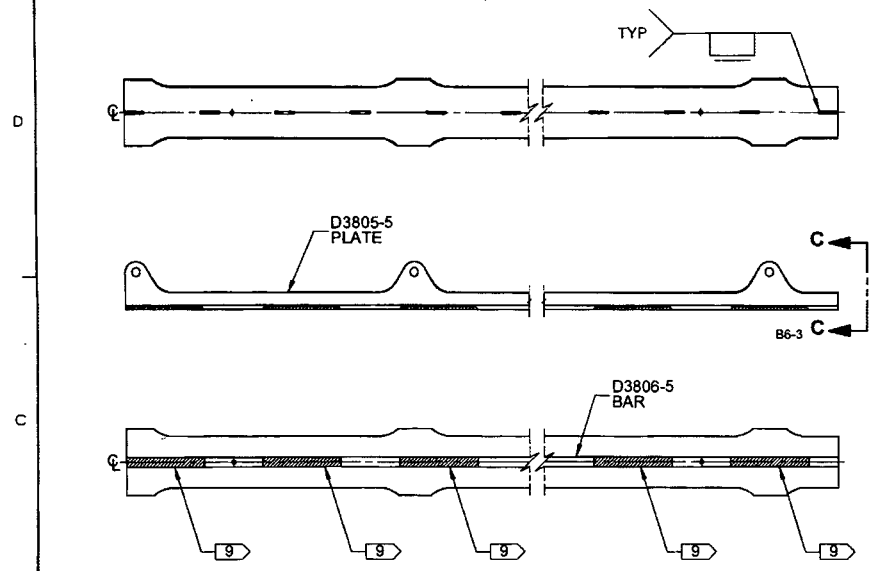
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

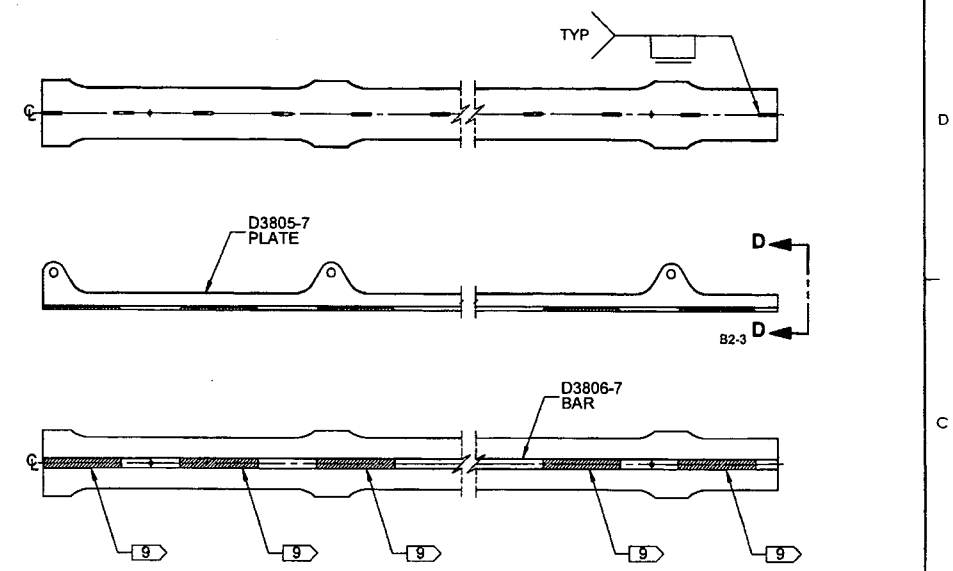
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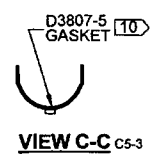
8 7 6 5 4 3 2 1



D3805-045 AFT WEARPLATE ASSY.



D3805-047 AFT WEARPLATE ASSY.



u/o 70855

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

RELEASED
 09.03.07
UNDER REVIEW
 11.08.19
 PER 7021-106

DESIGN	197	DART AEROSPACE USA, INC.	
DRAWN	15	PORT HADLOCK, WA	
CHECKED	15	DRAWING NO.	REV. A
MFG. APPR.	15	D3805	SHEET 3 OF 8
APPROVED	15	TITLE	SCALE
DE APPR.	15	WEARPLATE ASSY	NTS
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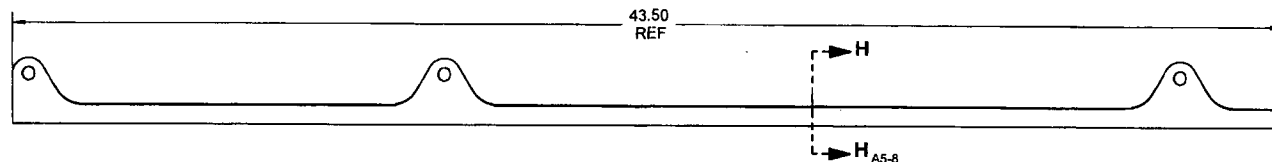
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

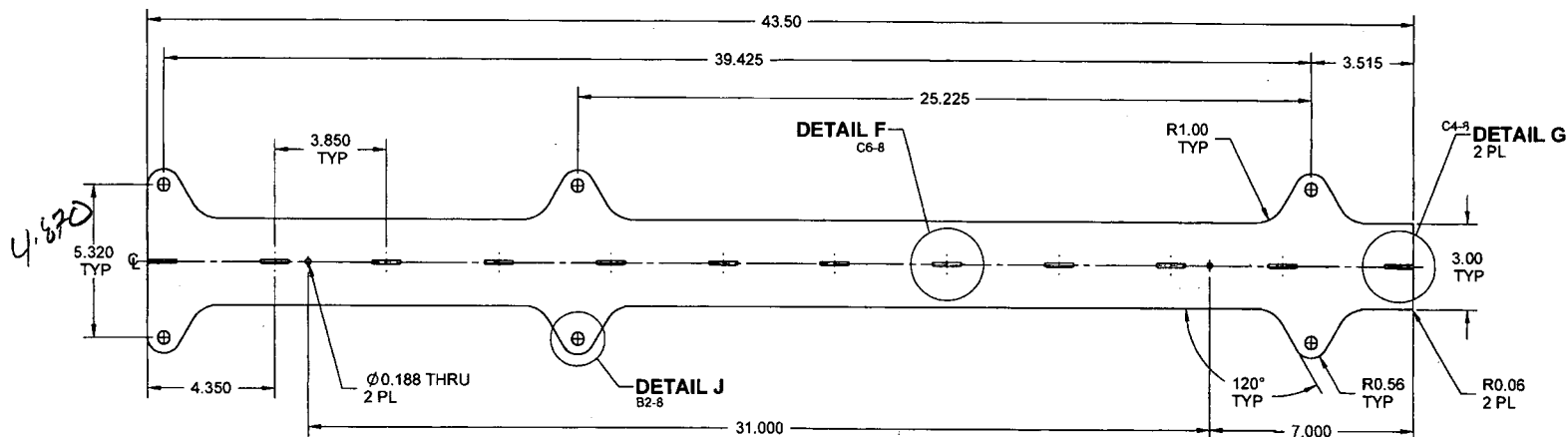
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3805-5 PLATE
(MAKE FROM D3805-5F)



D3805-5F PLATE

RELEASED
04 03 03
15 05 19
1000-106

UNDER REVIEW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

DESIGN	JP	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	ALS	DRAWING NO.	REV. A
MFG. APPR.	ALS	D3805	SHEET 6 OF 8
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

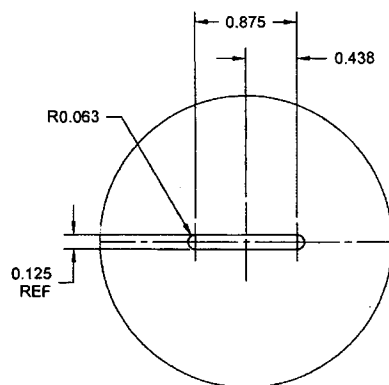
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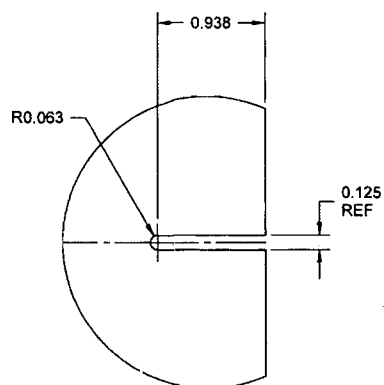
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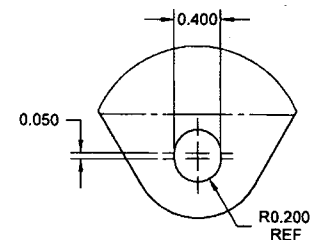
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



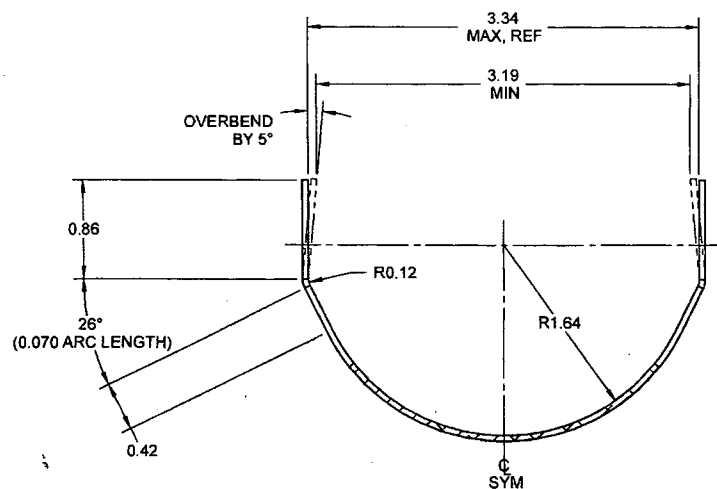
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

u/070859

RELEASED
07.09.03

18-06-02
NO LAMINAR
WIND TUNNEL
BOW 11-586

UNDER REVIEW

08.05.19

PER PAGE 106

DESIGN	147	DART AEROSPACE USA, INC.	
DRAWN	147	PORT HADLOCK, WA	
CHECKED	147	DRAWING NO. D3805	REV. A
MFG. APPR.	147		SHEET 8 OF 8
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